

must ship 24/09

Work Order ID 52253

Monday, September 21, 2009 2:24:54 PM



PRELIMINARY ISSUE

Page 1

Item ID: D3991-3

Accept



Setup Start



Revision ID: A-PRELIM

Item Name: Packer

Stop



Start Date: 9/22/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Bo

Date: 09-22-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3991

A-PRELIM

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg. D3991

Dwg Rev: PPE

Prog Rev: Lim

2-Deburr if necessary

IB 9-9-22

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00








Quality Control




IB 9-9-22

Work Order ID 52253

Monday, September 21, 2009 2:24:54 PM

Page 2

Item ID: D3991-3	Accept		Setup	Start	
Revision ID: A-PRELIM				Stop	
Item Name: Packer					
Start Date: 9/22/2009	Start Qty: 1.00		Cust Item ID:		
Required Date: 9/30/2009	Req'd Qty: 1.00		Customer:		
Reference:					
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start 
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	ENGINEERING APPROVAL <i>IN 9/21/09</i>			<u>3</u>			<i>6509.23</i>
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>3</u>	<u>9</u>		
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>OK 0909-23</i>			<u>(3)</u>			

Work Order ID 52253

Monday, September 21, 2009 2:24:54 PM



Page 3

Item ID: D3991-3	Accept		Setup	Start	
Revision ID: A-PRELIM				Stop	
Item Name: Packer					
Start Date: 9/22/2009	Start Qty: 1.00		Cust Item ID:		
Required Date: 9/30/2009	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

*Sold to Harvey Eagle
per ECN 09-673 P*

See ATTACHED ~~ECN~~ ECN

Charge to RD0309A & P

U 09-28

POSITIVE RECALL
EFFECTIVE 9/28/09 AUTH h
RELEASED _____ DATE _____

Picklist Print

Page 1

Monday, September 21, 2009 2:24:54 PM

Work Order ID: 52253



Parent Item: D3991-3RevA-PRELIM



Parent Item Name: Packer



Start Date: 9/22/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	64.3858	0.0200	.0600		
												
6061-T6 Sheet 0.032"												

1249-02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

64.3858

110063

0.9958

16954

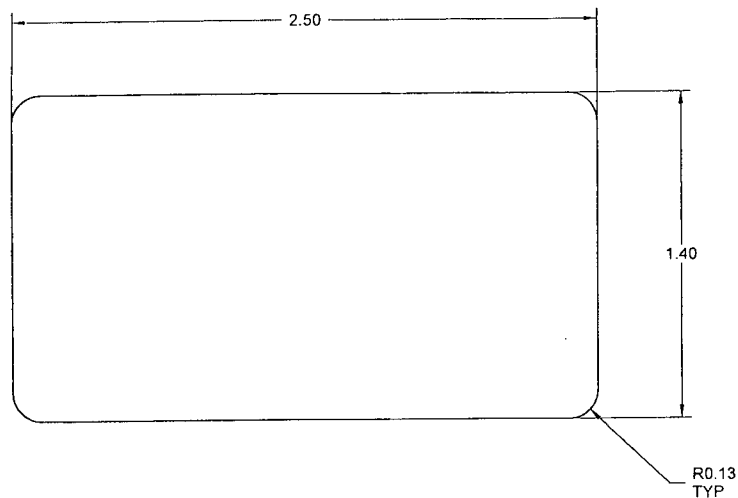
8.99

18375

54.4

110063

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WORK ORDER
NO. 52253



0.032
REF

PRELIMINARY ISSUE

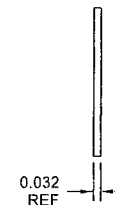
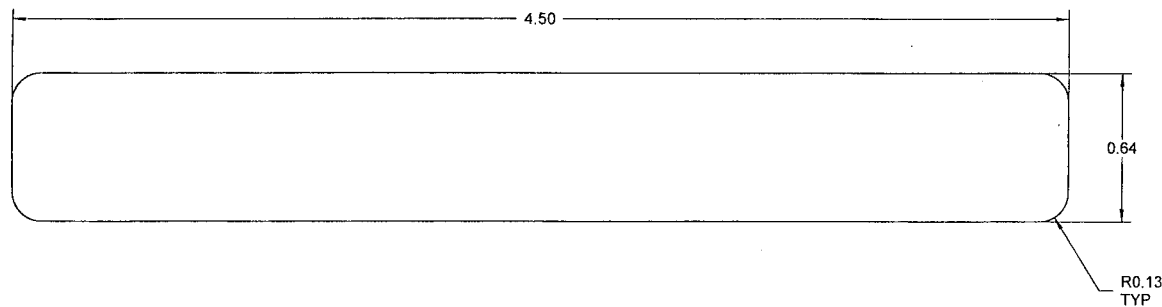
D3991-1 PACKER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		09.09.14	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3991		SHEET 1 OF 2	
APPROVED		TITLE		SCALE	
DE APPR.		PACKER		NTS	
DATE		09.09.14			
COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

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WORK ORDER
NO. 58253





D3991-3 PACKER

PRELIMINARY ISSUE
09/09/14
JMP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3991	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PACKER	NTS
DATE	09.09.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Date:

8/11/26

Batch No:

M110063

Supplier:

MAGNA

Dart P/O:

7606

Packing Slip: Yes ☒ No ☐Invoice: Yes ☐ No ☒Receipt: Cash ☐ Cr ☒Release Note Attached: Yes ☒ No ☐ N/A ☐Waybill Attached: Yes ☒ No ☐ N/A ☐Shipment Complete: Yes ☒ No ☐ N/A ☐QC6 Inspection: Yes ☒ No ☐ N/A ☐Work Order: ☒ N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

08/11/28

Received/Costing

R09587

Initial

CR

Location

H:\FORMS\Purchasing\approved\11/28/08

3 PC 6061-T6 .032" X 48" X 144"
L017763 3 PC/166 LB

3 PC 6061-T6 .032" X 48" X 144"
L017765 3 PC/66 LB

3 PC 286.66 859.98

3 PC 120.00 360.00

RECEIVED DEC 04 2008

11/28/08 18:14:21

Merchandise:	2,135.98
Surcharges:	
No Tax Costs:	
GST	106.80
Total Due:	2,242.78

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with and has been found to meet the applicable requirements contained therein, including any specifications forming a part of this description and that samples representative of the material and the composition have been tested and the mechanical properties shown in the face of this sheet.

Mary J. Lusk

Mary J. Lusk
Director of Manufacturing Development

Kenton P. Young

Kenton P. Young
Chief Assurance Manager

922270

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2008-04-24

2950767

00000

5099391-1

P.O. No./Govt Contract No.

Customer

Mfg. Order

780307JG001 Lot: 1

YARDE-SOUTHWINGTON DS-99391-1

Lot: 611761 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
Cast Number Chemical SI FE CO MN MG CR ZN TI
H2759114 Actuals 0.65 0.4 0.28 0.06 1.0 0.19 0.04 0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.672.1(a)]; it was manufactured in the United States

REC'D - COPIES (REV) 13:00

SMILE REINLD HIFERAT RD

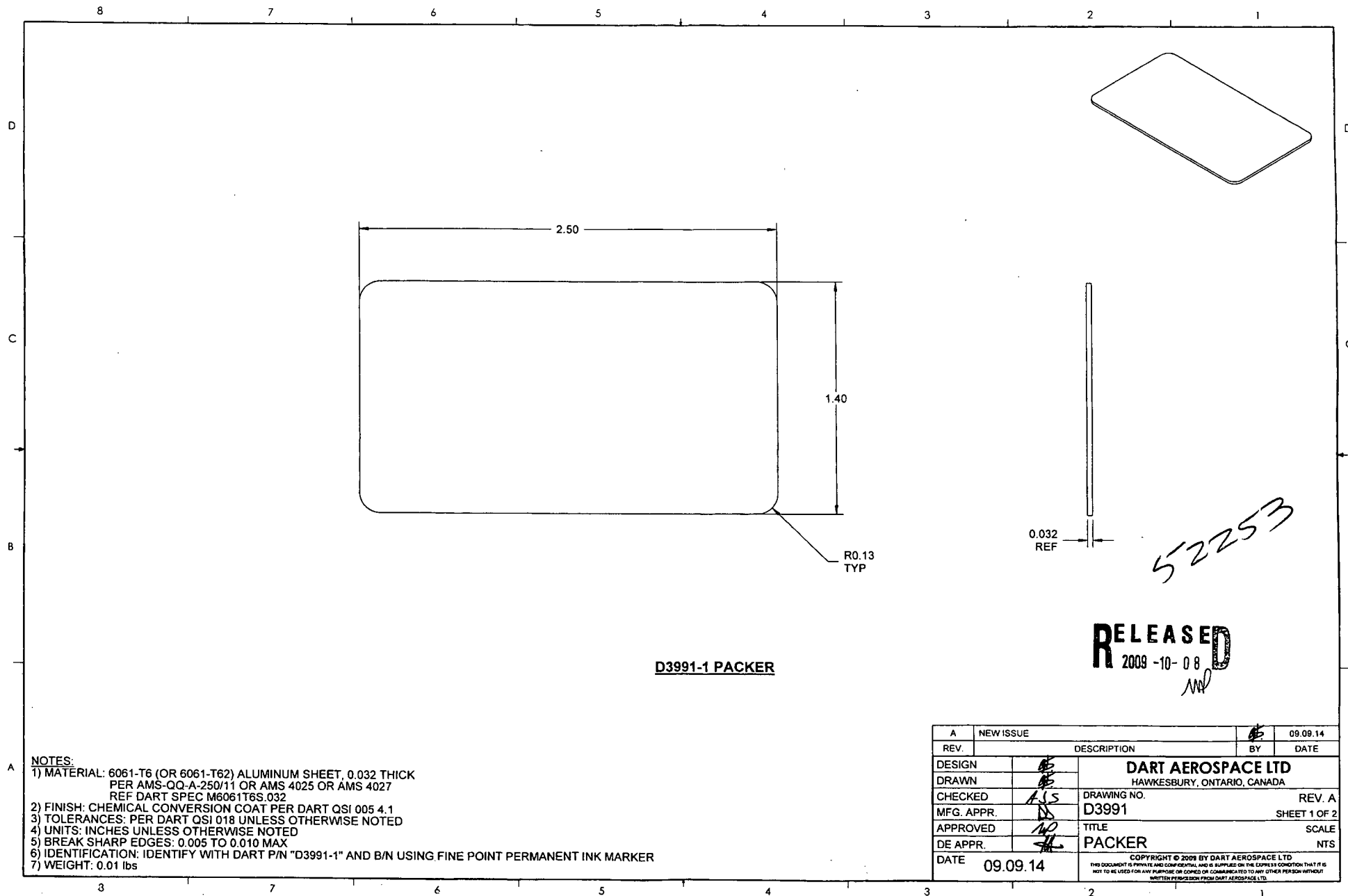
F. 001/US1

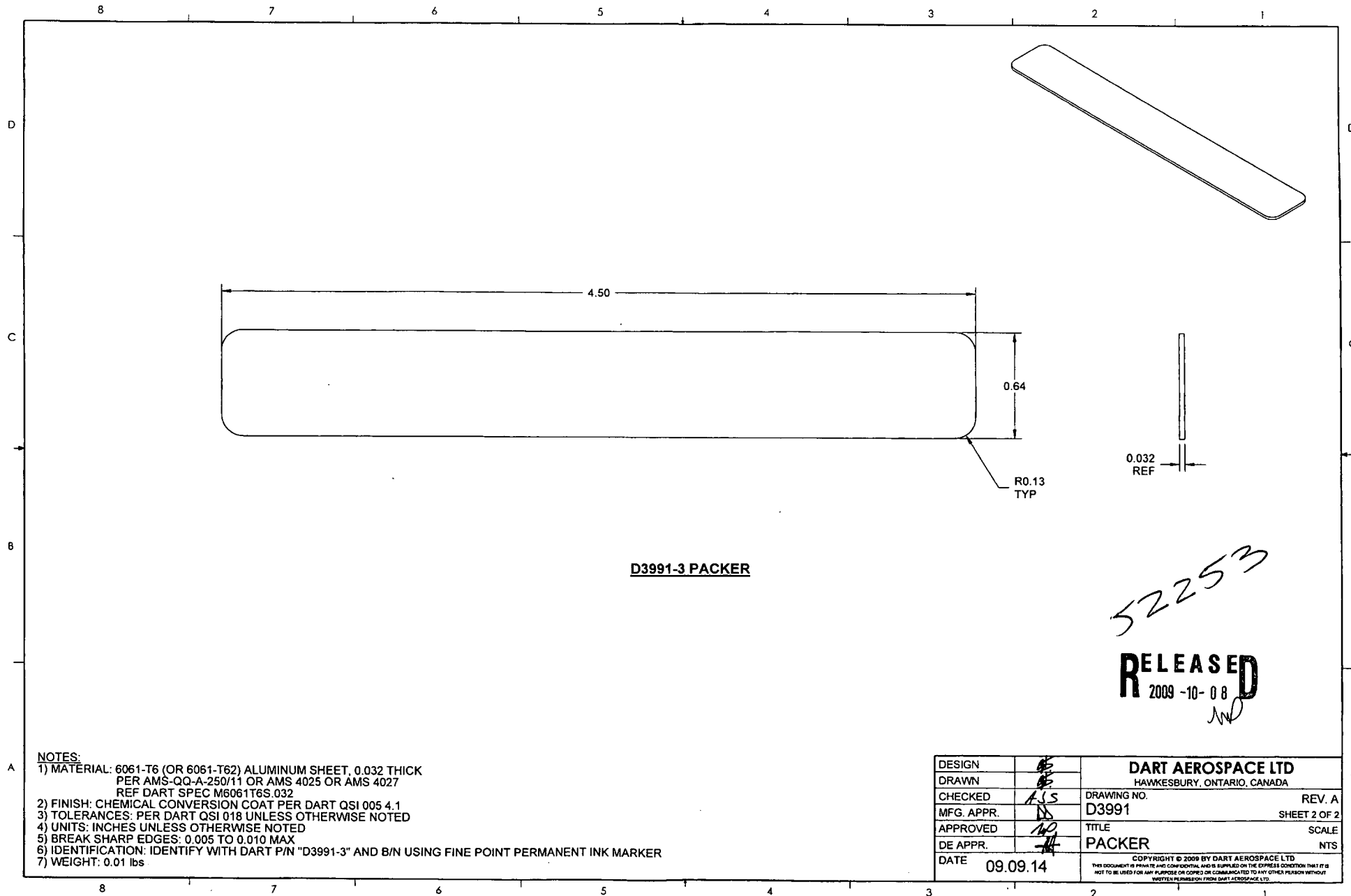
8811180000-5 MAGNA STAINLESS PO: 000174 Part #:

2000-99

2000-3

7/2008 WED 11:02 FAX 5143391292 Magna Stainless Ltd





NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
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- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.09.21	Job No.: P2010009	ADR Yes/No: No	ADR Date:	ECN #: 09- 673P
Product No.: D350-600 / D130-780 / D412-698	Created By: HS	Approved By: <i>[Signature]</i>		
Product Name: AS 350 Spacepod/Hinge Door Kits	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>[Signature]</i>
Production Engineering Coord	Y	EC	<i>[Signature]</i>
Production Document Control	N	JS	
Customer Technical Support	N	BS	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change:
Prelimin Release for parts for testing

Documents Affected:
D3622 Rev. B
D3991 Rev. A
D3992 Rev. A

PARTS MUST COMPLY ☒ **PREVIOUS PARTS SATISFACTORY** ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	N			
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	N			
11	Update Master Document List (MDL)	N			
12	Update Document Record (DR)	N			
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	Y	KJ		09.09.21 <i>[Signature]</i>
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	N			
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
22					
23					

Description / Action:
 - Parts required for testing, to be sent to Calgary on or before 09.09.25
 - Quantity required; D3622-3 (2), D3991-1 (1), D3991-3 (1), D3992-1 (1), D3992-3 (1)
 - create estimates for D3622-3, D3991-1, D3991-3, D3992-1, D3992-3
 - AS PARTS WILL BE USED FOR TESTING NO FINISHING IS REQUIRED. *NO MATERIAL CERTS*

ECN Verified & Complete: *[Signature]*

Date: 09/09/21